

20-8144



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

D3290-3

Job Sheet 209321



Part No: D3290-3

Job Qty: 6 pcs

DAS

21

9-59

Part Name: Window



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 4/23/20

Job Tracking No:

Created By: Jennifer Renwick

Due Date: 6/2/20

Description: SIOP

Type: Stock

Note: DWG REV C IPP A 04.08.18 New issue KJ/RF IPP B IPP C 07.05.29. Thermoform in-house DL IPP D 07.09.28 rev C dwg EC verified by: DD IPP E 07.11.28 Add -Hand finish deburring DL

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard Setup Run Hrs Hrs	Workcenter/Supplier	Sign-off
100	Purchasing	6 pcs	6/2/20		0.00 0.00	Purchasing - 1 Purchasing - 2 Purchasing - 3	HE MAY 28 2020
105	Packaging 2-1 - Receive - B4B	6 pcs	6/2/20		0.00 0.00	Packaging 2 - 1 - B4B Packaging 2 - 2 - B4B Packaging 2 - 3 - B4B Packaging 2 - 5 - B4B Packaging 2 - 4 - B4B Packaging 2 - 6 - B4B Packaging 2 - 7 - B4B Packaging 2 - 8 - B4B Packaging 2 - 9 - B4B Packaging 2 - 10 - B4B Packaging 2 - 11 - B4B Packaging 2 - 12 - B4B Packaging 2 - 13 - B4B Packaging 2 - 14 - B4B Packaging 2 - 15 - B4B Packaging 2 - 16 - B4B Packaging 2 - 17 - B4B Packaging 2 - 18 - B4B Packaging 2 - 19 - B4B Packaging 2 - 20 - B4B Packaging 2 - 21 - B4B Packaging 2 - 22 - B4B Packaging 2 - 23 - B4B Packaging 2 - 24 - B4B Packaging 2 - 25 - B4B Packaging 2 - 26 - B4B Packaging 2 - 27 - B4B	HE MAY 28 2020



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S279929



Part: D3290-3

Job No: 209321

Serial No/Batch: S279929

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/28/20

Plex 5/27/20 12:28 PM dart.lussier.patrick

				Packaging 2 - 28 - B4B	
				Packaging 2 - 29 - B4B	
				Packaging 2 - 30 - B4B	
				Packaging 2 - 31 - B4B	
				Packaging 2 - 32 - B4B	
				Packaging 2 - 33 - B4B	
				Packaging 2 - 34 - B4B	
				Packaging 2 - 35 - B4B	
				Packaging 2 - 36 - B4B	
				Packaging 2 - 37 - B4B	
110	QC 6	6 pcs	6/2/20	0.00 0.00	QC 6 - 9
					QC 6 - 68
					QC 6 - 61
					QC 6 - 40
					QC 6 - 81
					QC 6 - 82
					DAS 82 9-89
					JUN 0 1 2020
190	Packaging 3-1 - Stock - B4B	6 pcs	6/2/20	0.00 0.00	Packaging 3 - 1 - B4B
					Packaging 3 - 2 - B4B
					Packaging 3 - 3 - B4B
					Packaging 3 - 4 - B4B
					Packaging 3 - 5 - B4B
					Packaging 3 - 6 - B4B
					Packaging 3 - 7 - B4B
					Packaging 3 - 8 - B4B
					Packaging 3 - 9 - B4B
					Packaging 3 - 10 - B4B
					Packaging 3 - 11 - B4B
					Packaging 3 - 12 - B4B
					Packaging 3 - 13 - B4B
					Packaging 3 - 14 - B4B
					Packaging 3 - 15 - B4B
					Packaging 3 - 16 - B4B
					Packaging 3 - 17 - B4B
					Packaging 3 - 18 - B4B
					Packaging 3 - 19 - B4B
					Packaging 3 - 20 - B4B
					Packaging 3 - 21 - B4B
					Packaging 3 - 22 - B4B
					Packaging 3 - 23 - B4B
					Packaging 3 - 24 - B4B
					Packaging 3 - 25 - B4B
					Packaging 3 - 26 - B4B
					Packaging 3 - 27 - B4B
					Packaging 3 - 28 - B4B
					Packaging 3 - 29 - B4B
					Packaging 3 - 30 - B4B
					Packaging 3 - 31 - B4B
					Packaging 3 - 32 - B4B
					Packaging 3 - 33 - B4B
					Packaging 3 - 34 - B4B
					Packaging 3 - 35 - B4B
					Packaging 3 - 36 - B4B
					Packaging 3 - 37 - B4B
					DAS 21 9-89
					JUN 1 0 2020
200	QC 21 - SA	6 pcs	6/2/20	0.00 0.00	QC 21 - SA - 21
					QC 21 - SA - 70
					QC 21 - SA - 53

Part Op 100 - (Purchasing) ISSUE P/O: POHB046337 SUPPLIER: PLASTECH MANUFAC URI D3290-3 AS PER DWG C OF
 Descriptions: C IS REQUIRED
 105 - (Receive & Inspect for Damage & Mat'l Certs) Patrick Lussier

110 - (QC6- All purchased or subcontracted products) ***Windows need to be protected at all time***

190 - (Identify as per dwg & Stock Location:_____)

200 - (QC21- Final Inspection - Work Order Release)

PO Details

Canus Plastics Inc (ptf001-vc)



PO No: POHB046337

Line No: 1

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3290-3P	Window	6 Ea (1 ea)	100-Purchasing	5279927
MACRLICS.125	1/8" Polycast li Sheet	31.9800 sf (5.33 ea)	100-Purchasing	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
100-Purchasing	D3290-3P	6	0	0
	MACRLICS.125	32	1.000	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Window	26.580Inches ± 0.030	26.610 26.550	26.400	26.420
2	Window	16.080Inches ± 0.030	16.110 16.050	15.940	
3	Window	13.790Inches ± 0.030	13.820 13.760		
4	Window	12.400Inches ± 0.030	12.430 12.370		
5	Window	8.810Inches ± 0.030	8.840 8.780		

Plex 5/27/20 12:28 PM dart.lussier.patrick



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

PURCHASE ORDER

POHB046337



Supplier: PTF001-VC
Canus Plastics Inc
128 Walgreen Road
Ottawa
ON
K0A 1L0 Canada
Phone: 613-831-4640
Fax: 613-831-4624

PO No: POHB046337
PO Date: 4/23/20
Due Date: 5/18/20
Purchase Order Revision:
Revision Date:
Issued By: Lussier, Patrick
Phone: 613-632-5200 Ext: 276
plussier@dartaero.com

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Via: Ground
Pymt Terms: Net 30
Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Drawing	Supplier Part No	Item No	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	209321	D3290-3P	D3290 C DAS 82 9-89			Window : Various STC's As Per Dwg D3290 Rev. C	Firmed x6'		5/18/20	6 Ea	0 Ea	6 Ea	\$207.50/Ea	\$1,245.00
Grand Total:														\$1,245.00

Order Notes

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.

Procurement Quality Clauses

- A005 RIGHT OF ENTRY
- A007 FIRST ARTICLE INSPECTION (FAI) BY SELLER, (DOCUMENTATION MAINTAINED BY SUPPLIER)
- A012 CHEMICAL AND PHYSICAL TEST REPORTS
- A016 PERSONNEL QUALIFICATION
- A017 RAW MATERIAL IDENTIFICATION (AS APPLICABLE)
- A026 CERTIFICATION OF MATERIAL CONFORMANCE
- A041 QUALITY MANAGEMENT SYSTEM
- A042 DART NOTIFICATION BY SUPPLIER
- A043 RETENTION OF QUALITY DOCUMENT
- A048 COUNTERFEIT PARTS AVOIDANCE, DETECTION, MITIGATION AND DISPOSITION PROGRAM
- A049 SUPPLIER AWARENESS

Plex 5/27/20 12:35 PM dart.charest.martin



128 WALGREEN ROAD, OTTAWA, ON K0A 1L6
PHONE-613-831-4640

CERTIFICATE OF COMPLIANCE

SOLD TO: DART AEROSPACE

DATE: MAY 21, 2020

YOUR PURCHASE ORDER: PO HB046337

OUR INVOICE NO: 217803

DAS
82
9-89

LINE ITEM # 1

QUANTITY: 6

DESCRIPTION: REPLACEMENT EXTERIOR WINDOW FOR DWG D3290-3P REV C.

THESE PARTS WERE MANUFACTURED IN ACCORDANCE WITH:

DART QSI 018

PLASTECH PROCESS PR-01-01-D3290 REV 1.0 USING DWG D3290 REV C.

Note: USED 1 SHEET - 32 SF OF PLEXIGLASS G CLEAR CAST ACRYLIC SHEET PER LP-391
TYPE 1 GRADE C, 0.125 THICK (REF DART SPEC. M-ACRYLIC-S.125). BATCH# S151992.

THIS IS TO CERTIFY THAT THE MATERIAL FINISHES AND FUNCTIONAL REQUIREMENTS OF
THE ABOVE LISTED PARTS ARE IN ACCORDANCE WITH THE REFERENCE PROCUREMENT
SPECIFICATIONS, CONTROL DRAWINGS OR PARTS DESIGNATION AND LATEST REVISIONS
AS REFERENCED ON THE SUBJECT PURCHASE ORDER.

AUTHORIZED REPRESENTATIVE SIGNATURE

MARK PERRY, M.ENG.
PRESIDENT

CANUS PLASTICS INC.

3030 CONROY UNIT 107
OTTAWA ON K1G 6C2
Ph. (613) 232-2657 Fax (613) 232-6214
info@canusplastics.com
www.canusplastics.com

Packing Slip

0000220104

Date May 21, 2020
Customer P23336

Bill To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

Ship To: DART AEROSPACE
1270 ABERDEEN STREET
HAWKESBURY ON K6A 1K7

Ph. (613) 632-3336

Ph. (613) 632-3336

PO Number	F.O.B.	Salesperson	Order Date	Order Number
POH8046337	Our Dock	Mark Perry	May 21, 2020	0000220104
Ship Via		Payment Terms	Reference	
Pick up				

Ordered by PATRICK LUSSIER

(613) 632-5200 Ext 276

Part Number	Description	Ordered	Shipped	B/O	Weight	Extended Weight
-------------	-------------	---------	---------	-----	--------	-----------------

MFG

PART#D3290-3P, DRAWING D3290 C, WINDOW PER DRAWING D3290
REVC

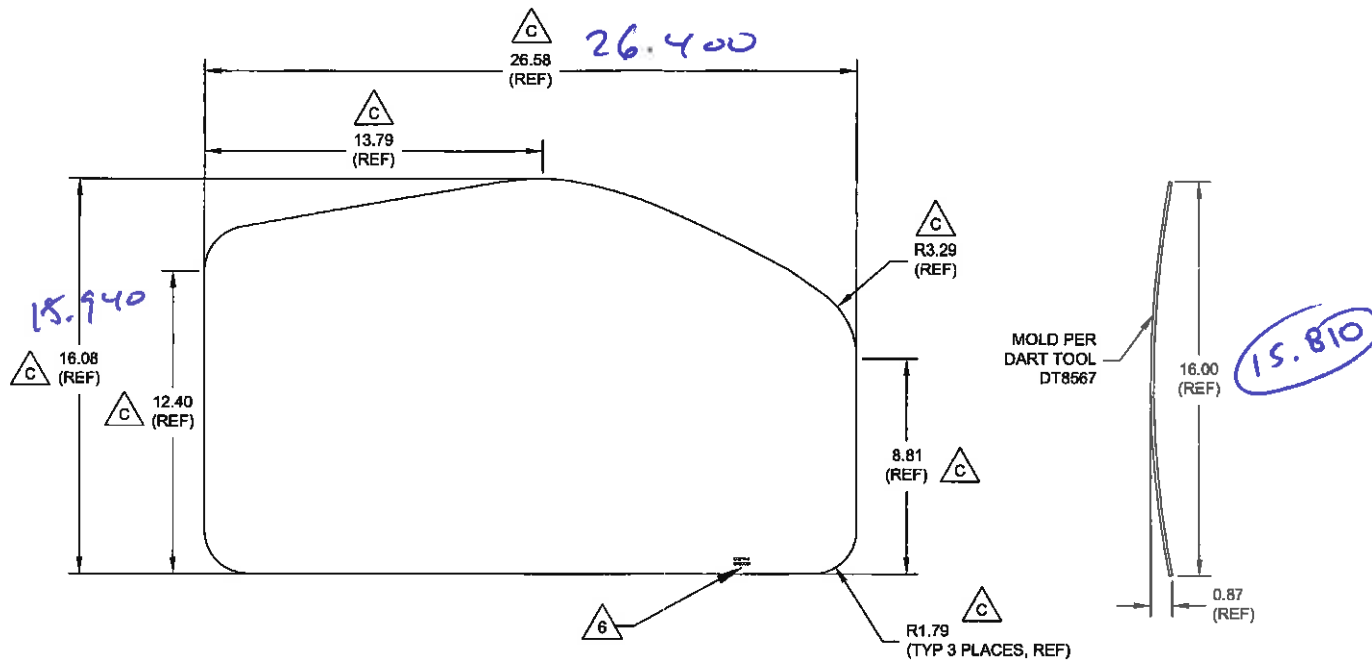
6

RECEIVED
MAY 20 2020
DART AEROSPACE LTD.

Date _____ Signature _____

Total

6



D3290-3 WINDOW

D3290-3 NOTES:

- 1) MATERIAL: POLYCAST II CLEAR ACRYLIC SHEET PER MIL-P-5425
OR PLEXIGLAS G CLEAR CAST ACRYLIC SHEET PER
LP-391 TYPE 1 GRADE C, 0.125 THICK
(REF. DART SPEC. M-ACRYLIC-S.125)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) REMOVE SHARP EDGES
- 6) IDENTIFICATION: ENGRAVE P/N "D3290-3" AND B/N ON LOWER EDGE
USE 0.125" HIGH LETTERS TO MAXIMUM DEPTH OF 0.005"
- 7) WEIGHT: 1.87 +/- 0.42 LBS
- 8) MOLD PER DART TOOL DT8567

UNDER REVIEW

DEO ATTACHED
RELEASED

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3290	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		REPLACEMENT WINDOW ASSEMBLY	1:5
DATE	07.07.24	COPYRIGHT © 2004 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

Entered:

JR Date: June 19/2020



NCR No.

20-8144

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

Route update only ☐

Job: 209321 Part No. D3290-3		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☒ Quality ☐																																	
Date: JUNE 1st 2020		Sequence #: QC 6 110		QTY Affected: 4 OF 6 PCS			MRB (QSI042) DAS 51 20/05/01 9-89																														
Description Work Order Deviation DURING INSPECTION IT WAS FOUND THAT THE DIMENSIONS OF THE FOLLOWING PARTS WERE UNDER TOLERANCE: 26.550" IS 26.420" (1/16TH ON EACH SIDE) 16.080" IS 15.940" (1/16TH ON EACH SIDE)				Disposition window dimension are critical and 4 of them was under the drawing dimension Scrap qty 4 windows				Completed By DAS 32 9-89 JUN 01 2020 Lead hand / Supervisor DAS 9 9-89 20-6-10 QC / QA Coordinator DAS 9 9-89 20-6-10																													
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☒ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY <table border="0"> <tr> <td>☐ Pressure/Forced</td> <td>☐ Contamination</td> <td>☐ Power Loss/Surge</td> <td>☐ Positioned Wrong</td> </tr> <tr> <td>☐ Bending</td> <td>☐ Misaligned/off center</td> <td>☐ Folio/Program</td> <td>☒ Outside Tolerance</td> </tr> <tr> <td>☐ Crushing</td> <td>☐ BOM/Route</td> <td>☐ Grain Direction</td> <td>☐ Drawing</td> </tr> <tr> <td>☐ Cracks</td> <td>☐ Broken/Damage/Defect</td> <td>☐ Weld</td> <td>☐ Finish</td> </tr> <tr> <td>☐ Crimp/Kink/Ripple/Wave/Twist</td> <td>☐ Incomplete/Unclear Instructions</td> <td>☐ Wrong Stock Pulled</td> <td>☐ Part Lost/Missing</td> </tr> <tr> <td>☐ Marks/Chatter</td> <td>☐ Drill Holes</td> <td>☐ Out of Sequence</td> <td>☐ Misread</td> </tr> <tr> <td>☐ Mislabeled</td> <td>☐ Fit/Function</td> <td>☐ Off-set/Set-up</td> <td></td> </tr> </table>								☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong	☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance	☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing	☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish	☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing	☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread	☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up	
☐ Pressure/Forced	☐ Contamination	☐ Power Loss/Surge	☐ Positioned Wrong																																		
☐ Bending	☐ Misaligned/off center	☐ Folio/Program	☒ Outside Tolerance																																		
☐ Crushing	☐ BOM/Route	☐ Grain Direction	☐ Drawing																																		
☐ Cracks	☐ Broken/Damage/Defect	☐ Weld	☐ Finish																																		
☐ Crimp/Kink/Ripple/Wave/Twist	☐ Incomplete/Unclear Instructions	☐ Wrong Stock Pulled	☐ Part Lost/Missing																																		
☐ Marks/Chatter	☐ Drill Holes	☐ Out of Sequence	☐ Misread																																		
☐ Mislabeled	☐ Fit/Function	☐ Off-set/Set-up																																			
		Other/Details:																																			